

Date: Tuesday, 4/18/2006 10:06:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP LEG	
Job Number	: 26684		Part Number	: D30771	
Estimate Number	: 11554		Drawing Number	: D3077 REV A2	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/18/2006 S.O. No. : N/A		Drawing Revision	: A2	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/10/2006 Qty: 20 Um: Each	
Previous Run	: N/A				
Written By	: See Comment Below				
Checked & Approved By	: JF 06.04.18				
Comment	: Est B0 02.11.18 Incorporated D3170-1 IPP KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S080	5052-H32 .080 Sheet
		Comment: Qty.: 0.6125 sf(s)/Unit Total : 36.7479 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch: M100742
2.0	SHEAR	
		Comment: SHEAR Cut blanks: 12.100" x 6.070" (+0.030/-0.000)
3.0	HAAS Water jet	
		Comment: HAAS CNC VERTICAL MACHINING #1 Cut as per Machine per Folio FA284 and Dwg D3077
4.0	QC2	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	
		Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr to take measurement

SAN 06:05:04

20

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H.M 06/05/04

20

8.0 QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

2060504 20

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/04

Job Completion



W 06/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26684
Description: Step Leg	Part Number:	D3077-1
Inspection Dwg: D3077 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

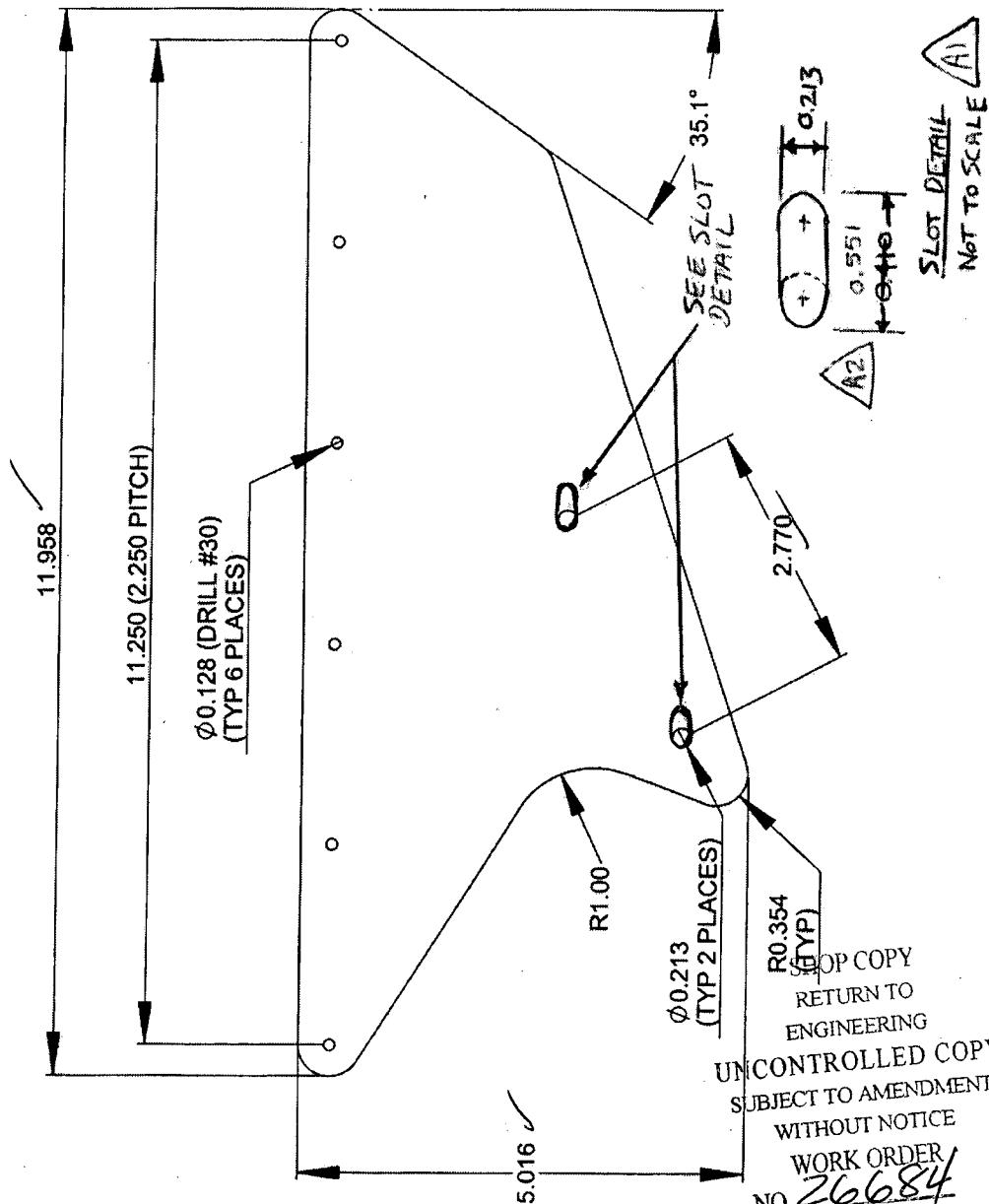
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	05-04-28	Date:	06-05-04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3077 REV. A SHEET 1 OF 1
DATE	02.09.11	TITLE STEP LEG SCALE 1:2

A	02.09.11	NEW ISSUE
A1	03.02.13 CP	ADD SLOTS
A2	03.02.27 CP	0.551 WAS 0.410

RELEASED
02.09.2011**D3077-1 STEP LEG**

- 1) MACHINE PER DWG FILE "D3077-1.SLDPRF"
- 2) MATERIAL: 5052-H32 (QQ-A-250(8)) .080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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